Wednesday, 1/11/2006 4:12:38 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 24101A

: 11698

P.O. Number

: NIA

This issue

: 1/11/2006

: 25436A

: NC

Prsht Rev. First Issue

: NA

S.O. No. : N/A

: LARGE FAB ASSY Type

Part Number Drawing Number

. D2721 REV C

Project Number

Drawing Name

: N/A

Drawing Revision Material

: C : N/A

Due Date

: 1/30/2006

: D2721041

: 206B STEP ASSY, LH

Qty:

3 Um:

Each

3

Written By

Previous Run

Checked & Approved By

Comment

: Est Rev:F

ABOVE USER BLAKE. As Per Ecn 766 06-01-06

SEE COMMENT EXION

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2622120C



Extrusion



Comment: Qty.:

1.0000 Each(s)/Unit

Total: Description

3.0000 Each(s)

Qty 1

Part# D2622-120C

Extrusion

Check Material for any Dents or Defects

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2721-1 using D2622 extrusion as per Dwg D2721

Deburr and bevel ends for welding

3.0 D2734 206 Step Endplate



Comment: Qty.:

2.0000 Each(s)/Unit Total:

6.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number

Description

Batch

D2734

End Cap

D34611 4.0

Comment: Qty.: 1.0000 Each(s)/Unit

Total:

3.0000 Each(s) ~

206 Step Lug

Pick:

Qty Part Number

Description

Batch

D3461-1

Plate

3252 [[

1.06-03-22

Dart Aerosp	pace Ltd
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	erospace Ltd									
W/O:			WORK ORDER	CHANGES						
DATE	STEP	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No):	PAR #:	Fault Category:	ault Category: NCR			NCR: Yes No DQA: Date:			
					QA:	N/C Close	d:	Date: _		
NCR:			WORK ORDER NON-COM	IFORMANCE	(NC	R)				
			Corrective Actic						T	

		WORK ORDER NON-CONFORMANCE (NCR)						
	Description of NC		Corrective Action	Section B		Varification	Ammunici	Approval QC Inspector
STEP	Section A Initial Chief Eng	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section C	Chief Eng	
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section A Initial Action Description	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Section C Chief Eng

Wednesday, 1/11/2006 4:12:39 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: 206B STEP ASSY, LH Customer: CU-DAR001 Dart Helicopters Services Part Number: D2721041 Job Number: 24101A Job Number: Seq. #: **Machine Or Operation:** Description: D34613 PLATE 5.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Description Qtv Part Number Batch D3461-3 Plate PLATE 6.0 D34615 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Batch Description Part Number Qty *3252*/3 D3461-5 Plate PLATE D34617 7.0 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Comment: Qty.: Pick: Part Number Description Qty D3461-7 Plate LARGE FABRICATION RESOURCE 1 LARGE FAB 1 8.0 Comment: LARGE FABRICATION RESOURCE 1 followed by Jig D Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT Batch: M12838 AL Rod Grind end cap welds flush QC5/9 WELD INSPECTION 9.0 Comment: WELD INSPECTION

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W/O:		WORK ORDER CH	CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	·	PAR #: Fault Category:	It Category: NCF			NCR: Yes No DQA: Date				
		·		QA:	N/C Closed	d:	_ Date: _			

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action	Section B		Verification	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	otion	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
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Wednesday, 1/11/2006 4:12:39 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: 206B STEP ASSY, LH Customer: CU-DAR001 Dart Helicopters Services Part Number: D2721041 Job Number: 24101A Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 10.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 POWDER COAT/CHEMICAL CONVERSION Comment: INSPEC LARGE FABRICATION RESOURCE 1 12.0 Comment: | ARGE FABRICATION RESOURCE 1. Inspect for foreign object per QSI 024 followed by Jig DT Weld Remaining end cap as per Dwg D2721 using Jig DT Batch: <u>M (8838</u> AL Rod A/R WELD INSPECTION QC5/9 13.0 Comment: WELD INSPECTION HAND FINISHING RESOURCE #1 14.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 06104108 Touch Up Alodine 15.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSIO QC3 16.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr Approva QC Inspector					
06.04.05	12,1	GRIND END COP WELDS flush	FF	cb-04.06	3	18 / aco40					

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	06/04/
			QA: N/C	Closed:	Date: _	

	\	WORK ORD	ER NON-CONF	RMANCE (NCR)			
	Description of NC		Corrective Action	Section B		Varification	Ammanal	A
STEP	Section A	Initial Chief Eng	Action Descri			Section C	Chief Eng	Approval QC Inspector
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	Johnston	Process Sheet
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: 206B STEP ASSY, LH
Job Number:	24101A	Part Number: D2721041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
17.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	nt: Wing Walk as per Dwg D2721 and C	
18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
19.0	nt: INSPECT POWDER COAT/CHEMIC PACKAGING 1	PACKAGING RESOURCE #1
19.0		PACINGING RESOURCE #1
Comme	nt: PACKAGING RESOURCE #1 Identify and Stock Location:	MA M
20.0	DC	DOCUMENT CONTROL
Comme	nt: DOCUMENT CONTROL Inspection Level 21	06/04/18
Job Completion		U Va. 04.18

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W/O:		WORK ORDER CHANGES								
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Part No	<u>;</u>	PAR #: Fault Category:	NCR: Yes No DQA:							
<u> </u>			QA: N/C Closed:		_ Date:					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC	Corrective Action		Section B		Verification	A	A	
		Section A	Initial Chief Eng	Action Descri	tion	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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